

Work Order ID 123963

123963

Page 1

September-04-14 11:53:57 AM

Item ID: D6005-128

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Material

Start Date: 9/04/14 Start Qty: 28.00

28

Cust Item ID:

Required Date: 3/30/15 Req'd Qty: 28.00

28

Customer:

Reference:

Approvals: Process Plan: MCT Date: 14-09-04

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D6005

B

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O:

a) Extrude as per Dwg D6005 length = 128" (Ref. D6005-128)

b) Material: 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11))
Seamless aluminum tube

c) Minimum ultimate tensile strength = 77ksi

d) Minimum tensile yield strength = 66ksi

Ensure material certification is attached

***EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE
SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH
AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS,
OR DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

CL 14/09/16 28

P-5

JTS

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 123963

123963

Page 2

September-04-14 11:53:57 AM

Item ID: D6005-128 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Crosstube Material
 Start Date: 9/04/14 Start Qty: 28.00 *28* Cust Item ID:
 Required Date: 3/30/15 Req'd Qty: 28.00 *28* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								
120	QC- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D6005								
130	Chemical Conversion Coat per OSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing	N/A								

24x Sp 15-05-6

(24) 15-05-19 DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Work Order ID 123963***123963***

Page 3

September-04-14 11:53:57 AM

Item ID: D6005-128 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Crosstube Material
Start Date: 9/04/14 Start Qty: 28.00 ***28*** Cust Item ID:
Required Date: 3/30/15 Req'd Qty: 28.00 ***28*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo <i>U/A</i>	DAS 9 9-89 0.00 0.00							
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo <i>Container</i>	0.00 0.00							<i>(24) 15-05-19</i> DAS 9 9-89
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>MLT</i> MAY 20 2015

MLT MAY 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
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Handling/Pre											
Material											
Operator											
Offset/Setup											
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Training											
Transport											
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FAULT CATEGORY			
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

September-04-14 11:54:01 AM

Page 1
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Work Order ID: 123963

123963

Parent Item: D6005-128

D6005-128

Parent Item Name: Crosstube Material

Start Date: 9/04/14

Required Date: 3/30/15

Start Qty: 28.00

Required Qty: 28.00

Comments: IPP Rev:C04.06.15Added tolerance to Step 2KJ/JLM
IPP Rev:D 08-09-23 fixe typo in dwg name DD verified by:EC IPP Rev:E
13.03.11 per dwg rev.b DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6005-128P		Purchased		No			Each	0.0000					
D6005-128P										28-241			
Crosstube Material										SP 15-05-6			

**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

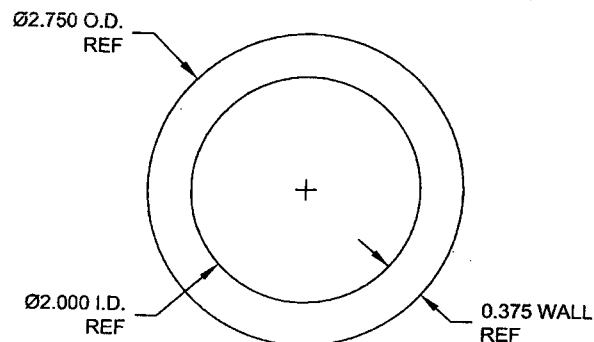
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 123963 MLS

14-09-04

NOTES

- 1) D6005-XXX CROSSTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 128" LONG TUBE: D6005-128

- 2) MATERIAL: 2.750 OD x 0.375 WALL 7075-T6/T6511 SEAMLESS ALUMINUM TUBE.
PER ASTM B210 OR WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi

- 3) TOLERANCES ARE AS FOLLOWS:

O.D.: ± 0.008 MEAN (± 0.012 INCLUDING OVALITY)
WALL: ± 0.015 MEAN (± 0.038 INCLUDING ECCENTRICITY)
LENGTH: XXX $\pm 0.125/0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH

- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

RELEASED
CP 13/2/7
PPR ECN 15-587

B	O.D. TOL. NOW 0.008 WAS 0.006, ADD ASTM B210	CP	12.10.29
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.10.29		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D6005
REV. B
SHEET 1 OF 1
TITLE CROSSTUBE MATERIAL
SCALE NTS

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25798**

Purchase Order Date 9/16/2014

PO Print Date 9/23/2014

Page Number 1 of 5

Order From :

VU-ALU001

Ship To : DART AEROSPACE LTD

ALUMINIUMWERK UNNA AG
630 3033 SOUTH PARKER RD
AURORA, CO 80014
USA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED \$

Contact Name

Vendor Phone 303 755 5672

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Wire

Currency

USD

FOB

DDP - (Delivered Duty Paid)

Ship To Contact

Ship To Phone

Ship Via:

Contract Shipping

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D6005-128P EXTRUDE AS PER DWG D6008-128 REV. B B123963	Crosstube Material	3/30/2015 Yes 3/30/2015		28.00 Each	\$523.00	\$14,644.00
						Line Total:	\$14,644.00
2	D6006-129P EXTRUDE AS PER DWG D6006-129 REV. A B123967	Crosstube Material	3/30/2015 Yes 3/30/2015		20.00 Each	\$1,002.00	\$20,040.00
						Line Total:	\$20,040.00
3	D6009-129P EXTRUDE AS PER DWG D6009-129 REV. A B123972	Crosstube Material	3/30/2015 Yes 3/30/2015		20.00 Each	\$1,254.00	\$25,080.00

Note:

9/23/2014



Boxmarking:

We hereby declare that the wooden packing material are totally free from bark and apparently

free from live plant pests

2015-05-6

Abnahmeprüfzeugnis 3.1 - DIN EN 10204:2005

Inspection Certificate 3.1 - DIN EN 10204:2005 / Certificat de Reception 3.1 - DIN EN 10204:2005

Kunde: Dart Aerospace Ltd.
Client:

1270 Aberdeen Street
K6A1K7 Hawkesbury, ON Canada

Zeugnisnummer: 26/15

Cert No.: / No. du certificat:

Bestellnummer: PO25798

Order No. / No. de commande

Auftrag: 54642/100

Our Reference/Notre Reference:

Produkt: Rohre nahtlos gepresst
Product / Produit: Tubes seamless extruded

Spezifikation: AMS - QQ - A - 200/11; -
Specification:

Werkstoff: 7075
Alloy/Alliage:

Zustand: T 6511
Temper/Etat:

Abmessung: 2,750 INCH x 2,000 INCH x 0,375 INCH x 128,000 INCH
Size / Dimension: D6005-128

Kennzeichnung: ALUnna - Cert No. 26/15 - 7075 - T 6511 - Cast No. 2700 - AMS - QQ-A - 200/11 - 2.750" OD X 0.375" Wall - Heat Lot No. 1303935 -
Marking/Marquage: ALUnna Order Conf. No. 54642/100-1- PO. 25798

Lieferung:
Delivered Material / Matériel délivré:

24 884

Country of Manufacture: Germany

Products are in accordance with applicable RoHS

1. Chemische Analyse

Chemical Analysis / analyse chimique

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Zr	Bi	Sn	Na
Charge/ min.			1,2		2,1	0,18	5,1						
Cast No. max.	0,40	0,50	2,0	0,30	2,9	0,28	6,1	0,20					
2700/14	0,078	0,166	1,517	0,024	2,334	0,203	5,758	0,036	0,002	0,0140	0,0001	0,0017	0,0002

Hydrogen content: 0,11

ccm/100 g Al Elements without indication < 0,01 %

country of melt manufacturer: Germany

2. Mechanische Eigenschaften

Mechanical Properties / Valeurs Mécaniques

Anforderungen Requirements	tensile (Rm) ksi	yield (Rp0,2) ksi	elongation 2" %	elongation A %	Hardness HB	Heat Lot No.
	81,0	73,0	7,0			
1	85,840	78,155	9,0			1303935

RMS: outside 25 - max. 12,0 µ"

Ergebnis der Prüfungen:

Es wird bestätigt, daß die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellannahme entspricht

Test results:

We confirm that the delivery has been tested and applies to the agreements made on receipt of the order

Resultats:

Nous confirmons que la livraison a été contrôlée et correspond avec les conventions faites à la réception de la commande

mergardtri



Certified acc. DIN EN ISO 9001:2008 and DIN EN 9100:2009

valid until 2016-11-10

Cert.- Reg. No.: 001959 QM08; 001959 ASH 09-1



ALUnna

[Signature]

13.01.2015

Aluminiumwerk Unna AG, Uelzener Weg 36, 59425 Unna, Germany

Abnahmebeauftragter

Aluminiumwerk Unna AG · Uelzener Weg 36 · D-59425 Unna

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ONT, K6A1K7
Kanada

Aluminiumwerk Unna AG
Uelzener Weg 36 · D-59425 Unna
Postfach 11 46 · D-59401
fon +49 (0) 23 03-206 - 0
fax +49 (0) 23 03-206- 116
info@alunnatubes.com
www.alunnatubes.com

page: 1
date: 9.04.2015
customer: 40980

delivery note

87280

your PO dated: 16.09.2014
your PO No.: PO25798
confirmation No.: 54642

contact: Petra Eisenblätter
Tel.: +(303) 755 5672
Fax: +(303) 755 5936
representative: CLAUS J. BETTER

CARRIER: Senator International
Your VAT No.:
AWU VAT No.: DE177869055
Country of origin: Germany

We supply acc. to our delivery terms and conditions:

item	quantity	unit	net kgs
100	24,000	PC	

AWU article: 36744 / Tariff no. 76082081

Customer article: D6005-128 2.750 X 0.375 X 128 / cust. drwg.

product: Tubes / seamless extruded / EN AW-7075 / round

condition: T 6511 / AMS-QQ-A-200/11(A)

outer diameter:	2,750 INCH Tol.	+0,012	-0,012
tol. for mean OD		+0,006	-0,006
inner diameter:	2,000 INCH		
wall thickness:	0,375 INCH Tol.	+0,038	-0,038
fixed length	128,000 INCH Tol.	+0,125	

test report acc. to EN 10204/3.1 / RM 531 / Rp0,2: 455

straightness 0,01 INCH / 1 FEET / RMS max.: outer 25

tol. on quantity +10 % -10 % / scurfed

2.750" OD 0.375" Wall, 128" lengths

Part Number D6005-128 crosstube

Surface Finish max. RMS 25

Tolerances per ASTM B210 / your drawing D6005

Tubes protected with corrosion protective oil

Tubes line marked

Commerzbank AG, Unna
Konto-Nr. 102 56 00 · BLZ 443 400 37
BIC/S.W.I.F.T. - Code: COBADE FF 443
IBAN: DE 90 4434 0037 01025600 00
Sitz der Gesellschaft: Unna
Amtsgericht Hamm, HRB 3045
Vorstand: Thomas Wiese
Vorsitzende des Aufsichtsrats: Irene Wiese

delivery note

87280

page: 2
date: 9.04.2015
customer: 40980

Packing: seaworthy wooden cases
number of packages: 1
number of pieces: 24

item	quantity	unit	net kgs
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200	18,000	PC	
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AWU article: 35311 / Tariff no. 76082081
Customer article: D6006-129 3.250 X 0.515 X 129 / cust. drwg.
product: Tubes / seamless extruded / EN AW-7075 / round
condition: T 6511 / AMS-QQ-A-200/11(A)

outer diameter:	3,250 INCH Tol.	+0,016	-0,016
inner diameter:	2,220 INCH		
wall thickness:	0,515 INCH Tol.	+0,052	-0,052
fixed length	129,000 INCH Tol.	+0,188	

test report acc. to EN 10204/3.1 / RM 531 / Rp0,2: 455

straightness 0,01 INCH / 1 FEET / RMS max.: outer 25

tol. on quantity +10 % -10 % / scurfed

3.250" OD 0.515" Wall, 129" lengths

Part Number D6006-129 crosstube

Surface Finish max. RMS 25

Tolerances per ASTM B210 / drawing D6006

Tubes protected with corrosion protective oil

Tubes line marked

Packing: seaworthy wooden cases
number of packages: 1
number of pieces: 18

item	quantity	unit	net kgs
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300	23,000	PC	
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AWU article: 37272 / Tariff no. 76082081
Customer article: D6009-129 3.500 X 0.625 X 129 / cust. drwg.
product: Tubes / seamless extruded / EN AW-7075 / round
condition: T 6511 / AMS-QQ-A-200/11(A)

outer diameter:	3,500 INCH Tol.	+0,016	-0,016
tol. for mean OD		+0,008	-0,008
inner diameter:	2,250 INCH		
wall thickness:	0,625 INCH Tol.	+0,063	-0,063
fixed length	129,000 INCH Tol.	+0,188	

test report acc. to EN 10204/3.1 / RM 531 / Rp0,2: 455

straightness 0,01 INCH / 1 FEET / RMS max.: outer 25

tol. on quantity +10 % -10 % / scurfed

3.500" OD 0.625" Wall, 129" lengths

Part Number D6009-129 crosstube

Surface Finish max. RMS 25

Tolerances per ASTM B210

Tubes protected with corrosion protective oil

Tubes line marked

Packing: seaworthy wooden cases
number of packages: 1

delivery note**87280**

page: 3
date: 9.04.2015
customer 40980

number of pieces: 23

Terms of payment: 30 days after date of delivery
terms of delivery: DDP(Delivered,Duty,Paid)

weight:	gross	1986,000	net	1650,000
Packstücke	3			

customer address:
DART AEROSPACE LTD.
1270 Aberdeen Street
HAWKESBURY ON K6A 1K7
Kanada